



Super Corr-A Solvent Replacement Study

2011 Environment, Energy Security & Sustainability Symposium & Exhibition

Abstract No. 12488

May 12, 2011

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Report Documentation Page				Form Approved OMB No. 0704-0188	
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1. REPORT DATE 12 MAY 2011		2. REPORT TYPE		3. DATES COVERED 00-00-2011 to 00-00-2011	
4. TITLE AND SUBTITLE Super Corr-A Solvent Replacement Study				5a. CONTRACT NUMBER	
				5b. GRANT NUMBER	
				5c. PROGRAM ELEMENT NUMBER	
6. AUTHOR(S)				5d. PROJECT NUMBER	
				5e. TASK NUMBER	
				5f. WORK UNIT NUMBER	
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES) Battelle,505 King Avenue,Columbus,OH,43201-2696				8. PERFORMING ORGANIZATION REPORT NUMBER	
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)				10. SPONSOR/MONITOR'S ACRONYM(S)	
				11. SPONSOR/MONITOR'S REPORT NUMBER(S)	
12. DISTRIBUTION/AVAILABILITY STATEMENT Approved for public release; distribution unlimited					
13. SUPPLEMENTARY NOTES Presented at the NDIA Environment, Energy Security & Sustainability (E2S2) Symposium & Exhibition held 9-12 May 2011 in New Orleans, LA. U.S. Government or Federal Rights License					
14. ABSTRACT					
15. SUBJECT TERMS					
16. SECURITY CLASSIFICATION OF:			17. LIMITATION OF ABSTRACT Same as Report (SAR)	18. NUMBER OF PAGES 25	19a. NAME OF RESPONSIBLE PERSON
a. REPORT unclassified	b. ABSTRACT unclassified	c. THIS PAGE unclassified			



Overview

- Project Team
- Background & Objectives
- Technical Approach
- Test Matrix
- Laboratory and Field Testing – Results
- Conclusions
- Recommendations



Project Team

- Primary Stakeholder – F-16 SPO, 388th Fighter Wing
- COTR – Paul Hoth 501 ACSS/GFLB
- Program Manager – John Stropki
- Task Leader – Jim Tankersley
- Support Staff
 - Bill Abbott (Consultant)
 - Annie Lane (Research Scientist)
 - Jill Gregory (Researcher)
- Subcontractor Support
 - Lektro-Tech, Inc., Tampa, FL (Ron Knight and Robert Kay)
 - Assistance w/ solvent down-selection and formulation
 - SMI, Inc., Miami, FL
 - Perform first article testing on new formulations



Background

- The Super Corr-A corrosion preventative compound (CPC) is qualified as a MIL-L-87177A, Type I, Grade B material for electrical connector applications
 - The Super Corr-A lubricant has had two solvent-related formulation modifications since 1994 (CFC-113 and HCFC-141B)
 - Super Corr-A has met or exceeded performance requirements in extensive evaluations by Hill AFB
- The current Super Corr-A formulation contains an HCFC AK225T solvent
 - Considered Class II Ozone Depleting Substances (ODS)
 - Banned in the European Union (EU) and Canada on 1 January 2009
- All maintenance and manufacturing operations in the EU requiring use of MIL-L-87177A are currently shutdown with no alternative replacement identified
- Unless a replacement solvent can be implemented, use of these ODSs will also be prohibited in the United States beginning in 2015



Objective & Approach

Objective:

Identify a more environmentally friendly and COTS alternative to the HCFC AK225T solvent currently in the Super Corr-A lubricant.

Program Approach:

- Research US and EU compliant solvents with chemistry compatible with Super Corr-A CPC
- Define material and performance requirements based on previous assessments of lubricants
- Conduct laboratory and field testing for comparative evaluation of the lubricant performance containing the alternative solvents
- As required, update MIL-L-87177A specification and associated process order



Test Matrix

- Test plan includes nine CPC formulations and one control
 1. Existing Super Corr-A formulation with AK225T solvent
 2. Previous Super Corr-A formulation with 141B solvent
 - 3-6. Super Corr-A formulated with 4 solvent candidates
 - a. DuPont Vertrel® SDG w/ current concentration of CPCs
 - b. DuPont Vertrel® SDG w/ higher concentration of CPCs
 - c. Kyzen Cybersolv® 141R w/ higher concentration of CPCs
 - d. Kyzen Cybersolv® 141R w/ current concentration of CPCs
 7. ILFC 1006 CON-TAC
 8. Zip-Chem D-5026NS
 9. Zip-Chem D-5026NS with alternative propellant (Noxit-86)



MIL-L-87177A Assessments

- SMI Laboratories conducted first article testing specified in MIL-SPEC to validate performance characteristic requirements of experimental lubricant formulations
- **Results:** New and old formulations of Super Corr-A do not meet first article requirements of MIL-L-87177A
 - Original formulations were never tested
 - Both formulations perform appropriately for intended application
- **Recommendation:** Update first article requirements and revise MIL-SPEC
 - Stakeholders include; Hill AFB, DLA-Richmond, AFRL/CTIO, and AFCPCO



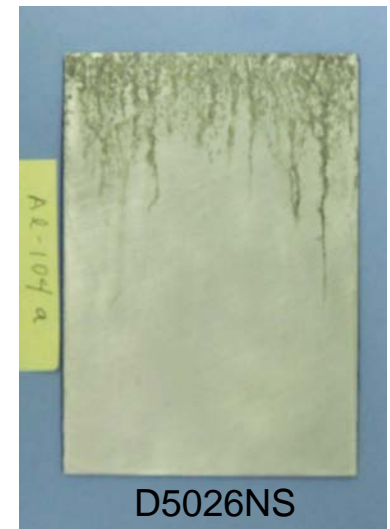
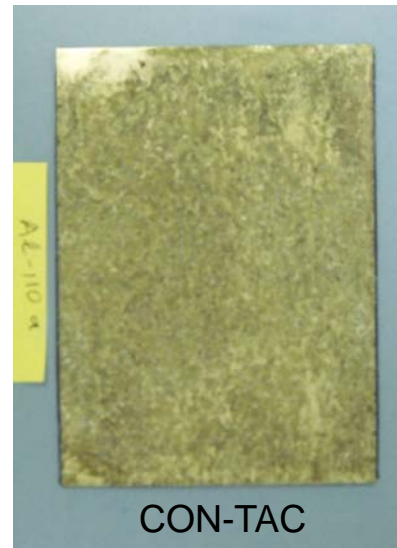
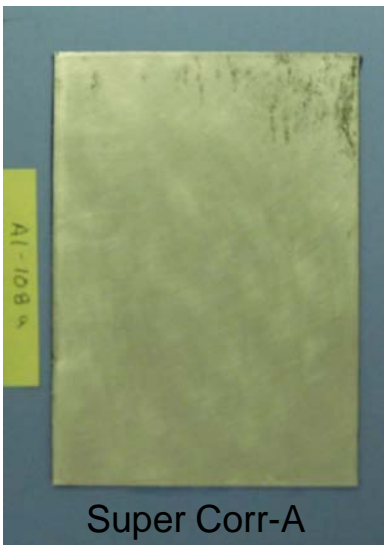
First Article Testing Results

Requirement	Test Method Specification	Limit	Result
Dryness	MIL-SPEC 4.6.1	0.0100 gram (max)	Failed
Flash Point	ASTM D1310	243 C/470 F (min)	Inconclusive
Dielectric Breakdown	ASTM D877	24,000 volts (min)	Failed
Lubricity	ASTM D226	1.20 mm wear scar diameter (max)	Failed
Residue Solubility	MIL-SPEC 4.6.3	No visible residue	Failed
Leakage	MIL-SPEC 4.6.4	No leakage or distortion	Passed
Content	MIL-SPEC 4.6.5	16 ounces (min)	Failed (container content 12 oz.)
Performance of pressurized containers	MIL-SPEC 4.6.6	Uniform spray, panel adherence, no sagging	Passed
Oxidation Stability	ASTM D942	<5 pounds/100 hours	Failed
Grade B Corrosion	ASTM B117	No corrosion after 168 hours	Passed
Sprayability	MIL-SPEC 4.6.9	Sprayable w/ no clogs	Passed

Battelle Laboratory Results

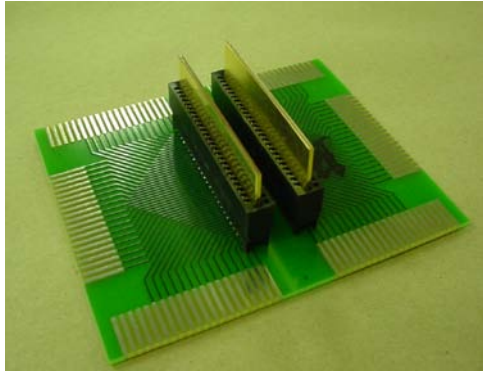
• Grade B Corrosion Testing

- Alternative Super Corr-A formulations showed improved corrosion resistance in salt fog exposure testing
- Most extensive pitting damage noted with the control and CON-TAC
- “Streaked” pitting noted on Noxit-86, D5026NS; may have been caused by formation and collection of water droplets along top edge





Battelle Laboratory Results - Connector Card Testing



Conditions:

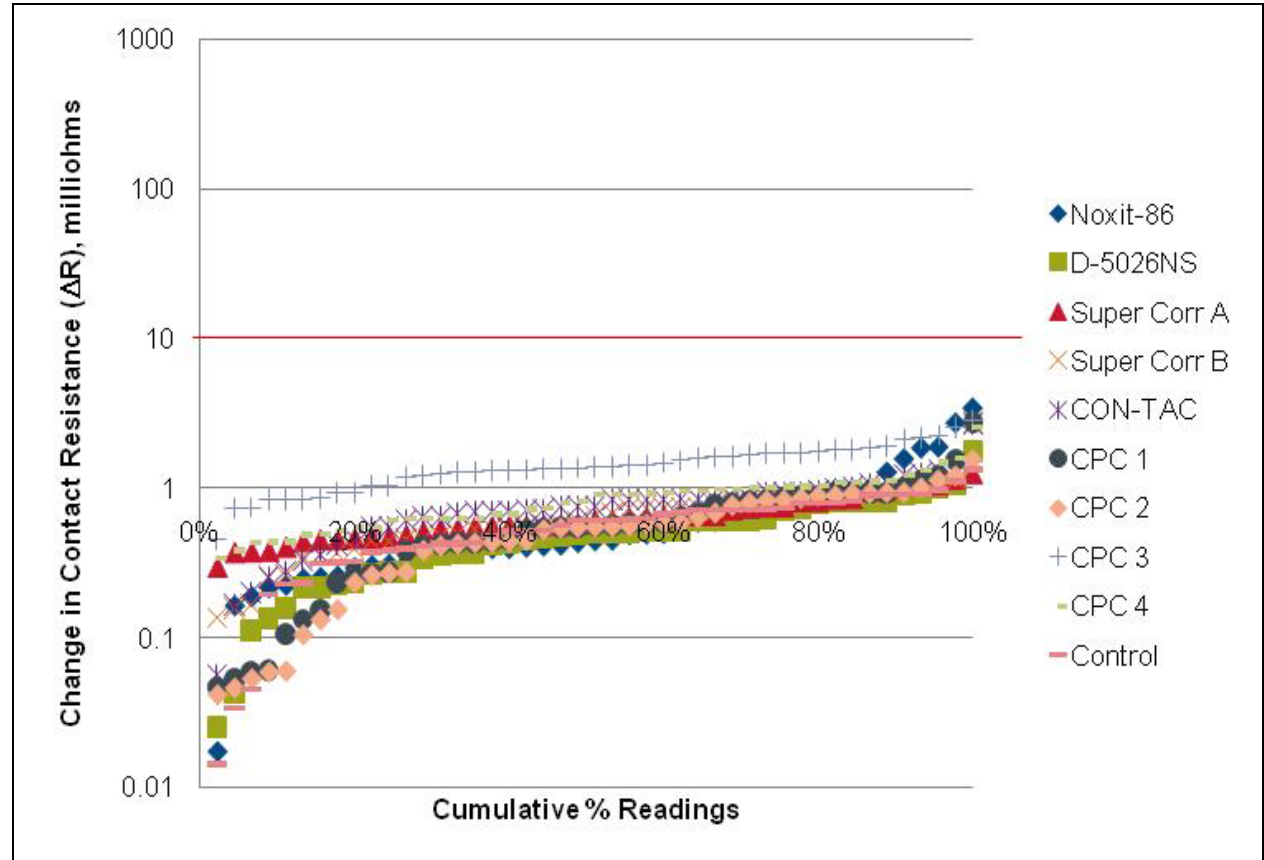
- 1000 hours
- 80° C (176° F)

Requirements:

- $\Delta R < 10$ milliohms

Results:

- All passed



**Change in Contact Resistance Resulting from Thermal
Aging Exposure Testing of Coated Electrical Connectors**



Battelle Laboratory Results – Low Temperature Testing

Conditions:

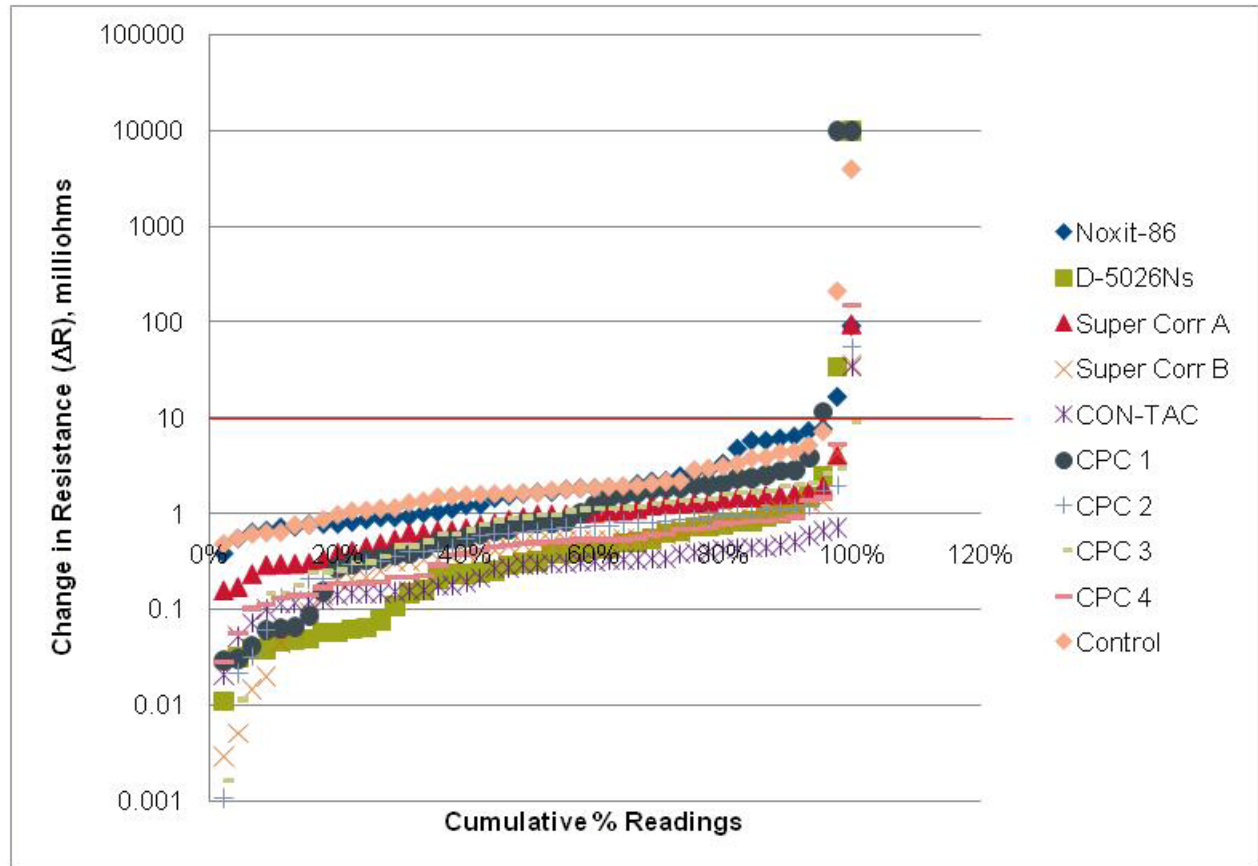
- Cycling at 25°, 5°, -15°, -35°, -55°, -15°, 5°, 25°
- 15 minutes @ each temperature

Requirements:

- $\Delta R < 10$ milliohms

Results:

- Only CPC No. 1 failed



**Change in Contact Resistance Resulting from Low Temperature
Cycling of CPC Coated Electrical Connectors**



Battelle Laboratory Results – Disturbance Cycle Testing

Conditions:

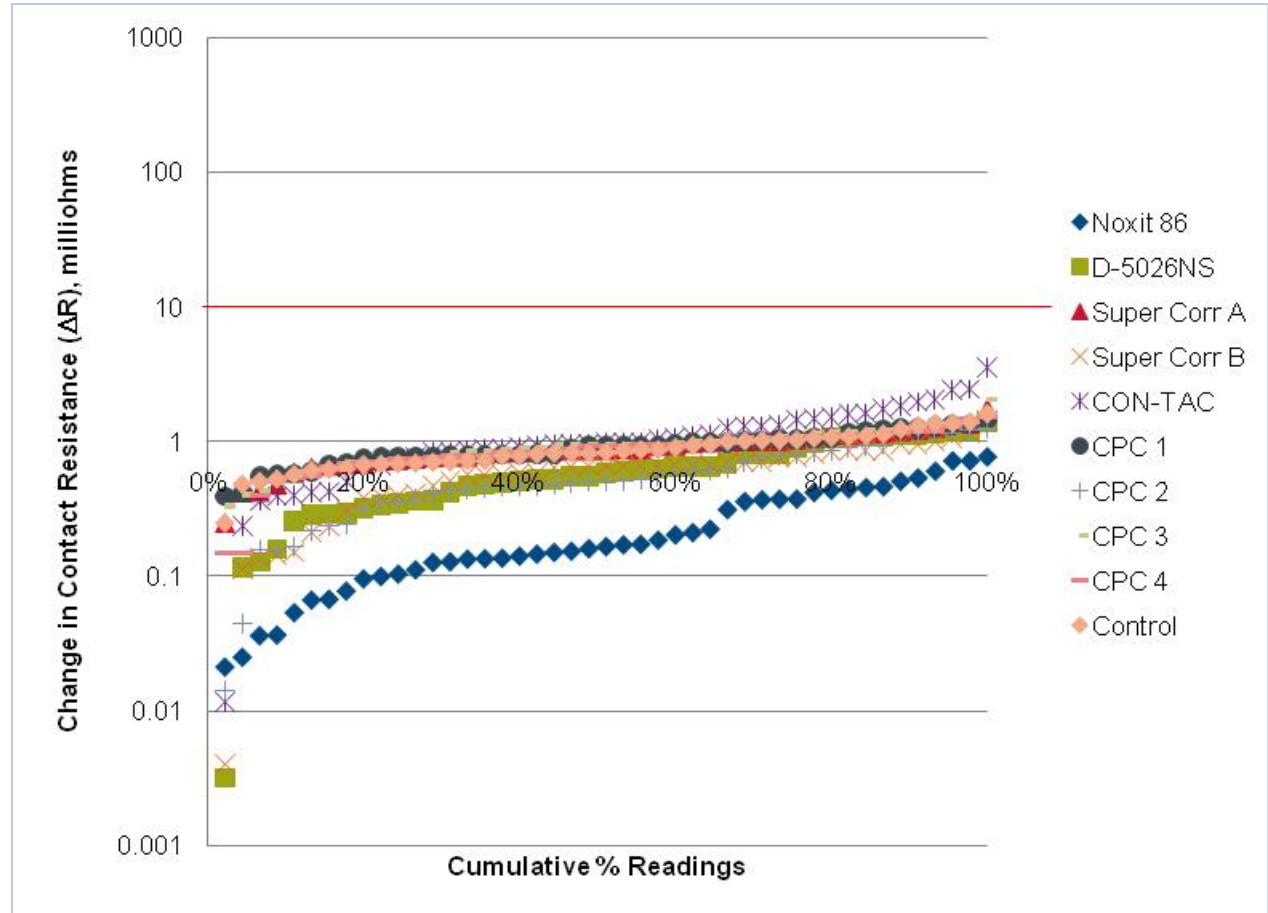
- 100 demate/remate cycles

Requirements:

- $\Delta R < 10$ milliohms

Results:

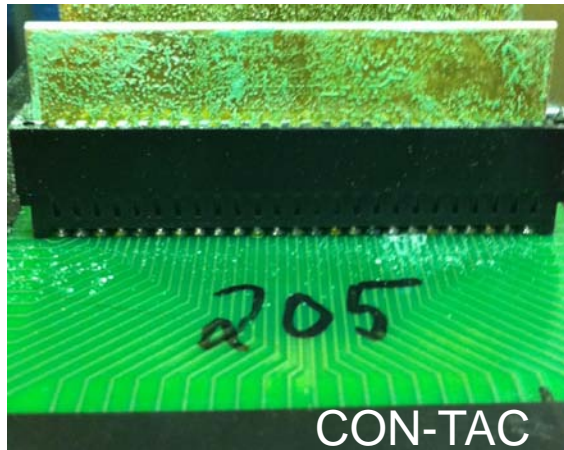
- All passed



**Change in Contact Resistance Resulting from 100 Disturbance Cycles
Completed on Coated Coupons attached to Connector Card**



Battelle Laboratory Results – Class II Flowing Mixed Gas Testing



Conditions:

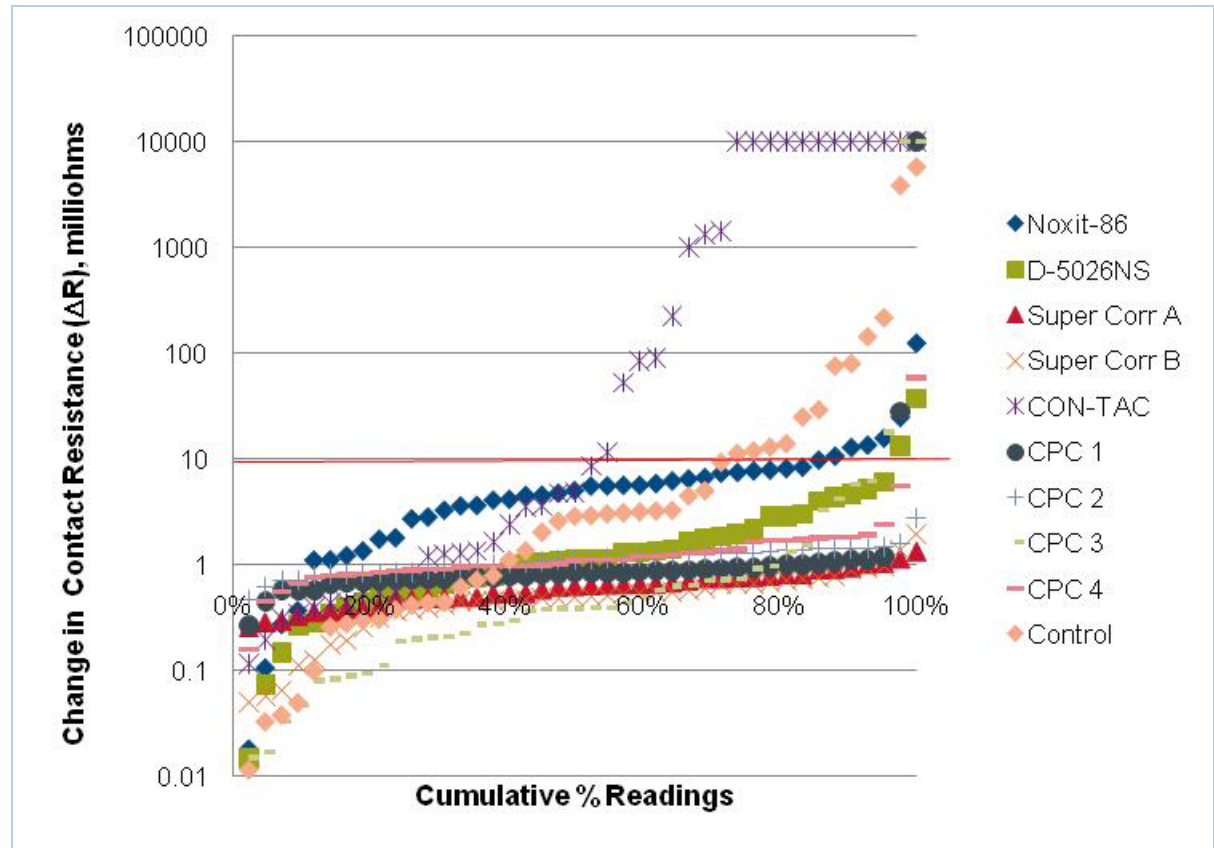
- 10 day exposure

Requirements:

- $\Delta R < 10$ milliohms

Results:

- CPCs No. 1 & 3, CON-TAC, and Noxit-86 failed



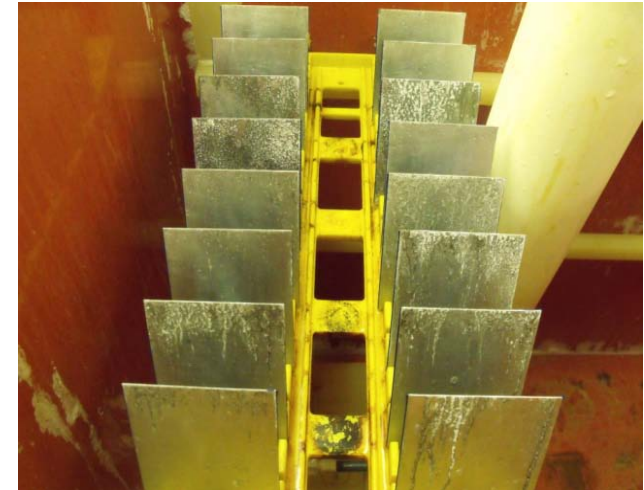
**Change in Contact Resistance After Exposure of Coated
Coupons to Class II Flowing Mixed Gas Test**

BUSINESS SENSITIVE



Battelle Laboratory Results – Grade B Corrosion Testing

CPC	Panel 1	Panel 2	Panel 3	Average Score (Max: 5)
Control	5	5	5	5.0
CPC No. 1	2	2	2	2.0
CPC No. 2	1	2	1	1.3
CPC No. 3	1	1	1	1.0
CPC No. 4	1	1	2	1.3
Super Corr A	3	2	1	2.0
Super Corr B	1	1	2	1.3
CON-TAC	5	5	4	4.7
Noxit-86	3	2	3	2.7
D-5026NS	3	2	3	2.7



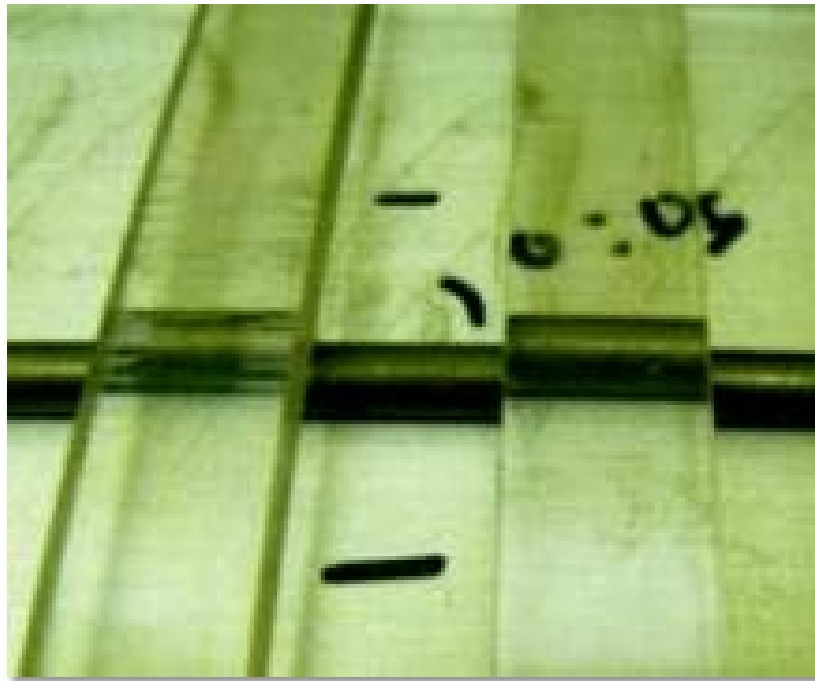
**Salt Fog CPC Ratings Calculated from Pit
Density Evaluation Referenced in ASTM
G46-94 and ASTM D610-08**

**Photographs Documenting Placement of Coated
Panels in ASTM B117 Salt Fog Cabinet and
Corrosion Pitting Noted on Coupons Coated with
CON-TAC CPC**



Battelle Laboratory Results – Polycarbonate Compatibility (canopies)

Consistent with previous testing, crazing noted with CON-TAC,
AK225T (slight), 141-B (dramatic)

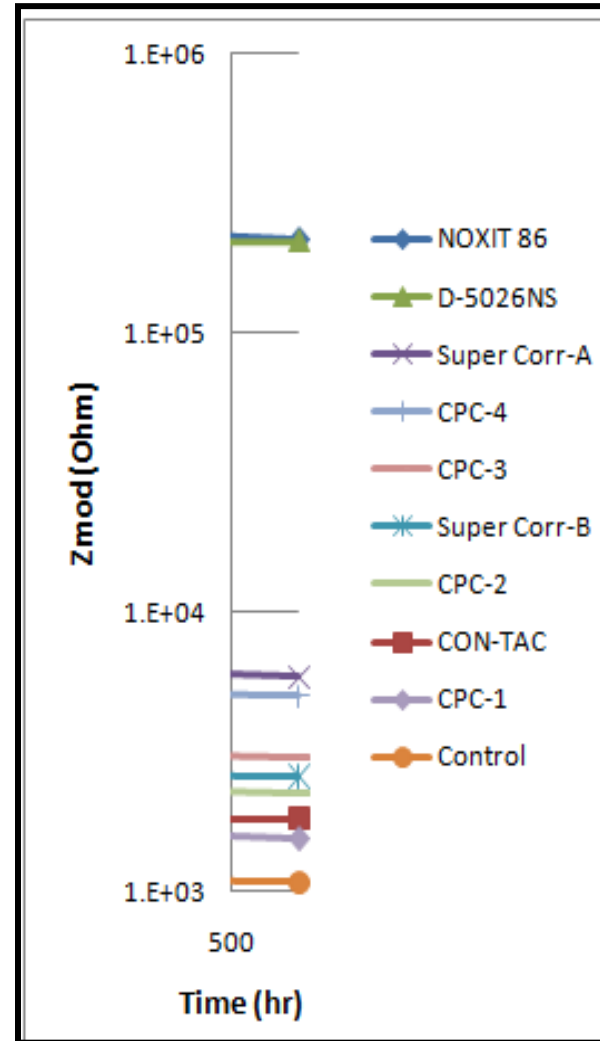


Polycarbonate Stressed Coupons:
CON-TAC (left), Control (right)



UC Laboratory Testing Results

Ranking of EIS Data	
Noxit86	1
D-5026NS	2
Super Corr-A	3
CPC-4	4
CPC-3	5
Super Corr-B	6
CPC-2	7
CON-TAC	8
CPC-1	9
Control (uncoated)	10

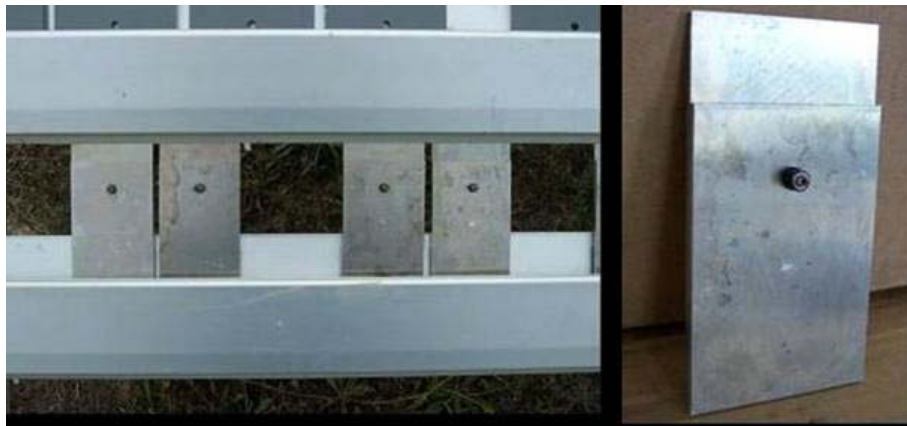
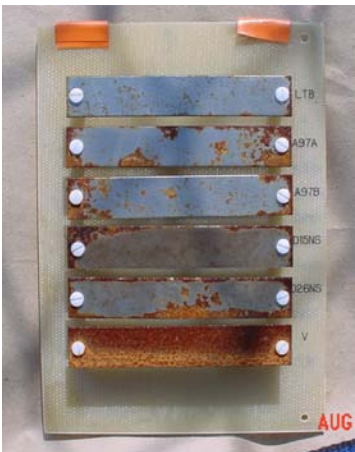




Battelle Field Testing

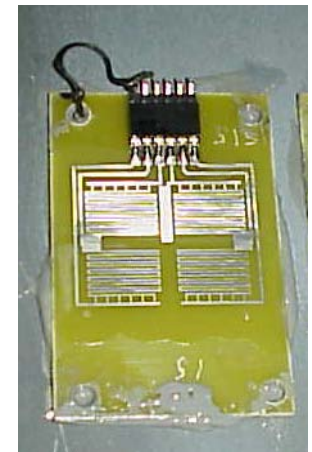
Test Type	Tests	Test Reference	Sample Size	Time Periods	Replicates	Sample Material
Field Exposure Testing	Connector Field Testing	Abbott 1996 report	10 CPCs	3 (1 mo, 3 mo, 6 mo)	50 (pin count)	Test connectors with gold-plated bars (2 to a PC board)
	Corrosion Coupons	Abbott 1996 report	10 CPCs	3 (1 mo, 3 mo, 6 mo)	1	Rack with 5 steel coupons
	Lap Splice Testing	Rice 2004 report	10 CPCs	3 (1 mo, 3 mo, 6 mo)	1	Lap splice fixture with steel coupon fastened to 2024 T3 Al coupon
	Steel Sensors	Recent Abbott work	10 CPCs	Measurements in place at 1 mo, 3 mo, 6 mo	1	Steel sensors

Corrosion Coupons



Lap Splice Fixtures

Steel Sensor



BUSINESS SENSITIVE



Battelle Field Testing Results - Corrosion Testing Summary

CPC	Average Weight Loss (g)	Average Corrosion Rate (mpy)
D-5026NS	0.14590	2.22
CPC 2	0.21215	3.23
CPC 4	0.21465	3.27
Noxit 86	0.23494	3.58
CPC 1	0.32854	5.01
CPC 3	0.33280	5.07
Super Corr-A	0.33346	5.08
Super Corr-B	0.35096	5.35
CON-TAC	0.43267	6.59
Control	0.51872	7.91

***Average for each CPC over the 4 month period with the three location sets combined**

**CPC Lubricant Ranking of Coated Corrosion Coupons
Based on Weight Loss**

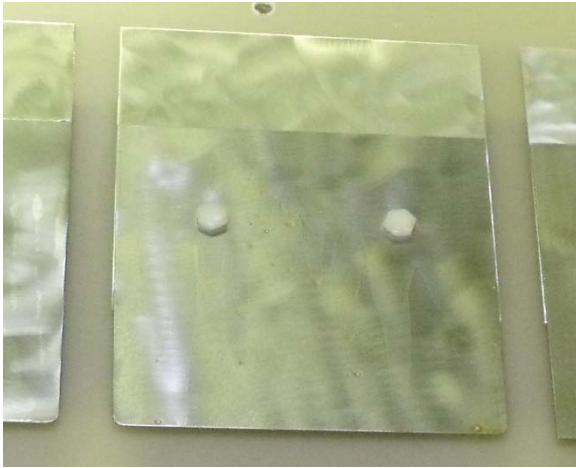


Battelle Field Testing Results - Summary

- The worst corrosion resistance was measured for the control or uncoated coupon sets,
- The best corrosion resistance was measured for the coupon sets coated with the D-5026N lubricant,
- The corrosion resistance of the CPC-2 lubricant was only slightly lower than the performance measured for the D-5026N material,
- The corrosion related performance of the coupons coated with the Noxit-86, CPC-3, CPC-4, Super Corr-A and Super Corr-B was identical.



Battelle Field Testing Results – Lap Splice Testing



**Area of CPC Application
Along Upper Edge of Lap
Splice Coupons**



**Lap Splice Coupon Sets Mounted on
Chain Link Fence at FMRF**



Battelle Field Testing Results – Lap Splice Testing Summary

	West Jefferson			FMRF			
CPC	1 mo.	3 mo.	4 mo.	1 mo.	3 mo.	4 mo.	Total (Max: 60)
Control	1	0	1	0	0	0	2
CPC No. 1	3	2	2	1	0	1	9
CPC No. 2	3	3	1	2	1	0	10
CPC No. 3	2	5	9	2	2	0	20
CPC No. 4	3	3	3	3	2	0	14
Super Corr A	3	2	1	1	0	0	7
Super Corr B	3	0	2	2	0	0	7
CON-TAC	3	0	2	1	0	0	6
Noxit-86	10	5	10	10	3	3	41
D-5026NS	10	9	8	9	4	4	44

**Ranking Scores for CPC Coated Lap Splice Coupons
(ref. ASTM D610-08)**

Battelle Field Testing Results – Steel Sensors at FMRF and West Jefferson

- Horizontally mounted sensors had increased corrosion
- Visual corrosion on controls, CON-TAC, and D5026NS variants
- CPC No. 2 consistently showed the least change in resistance



Vertical



Horizontal



Conclusions

- No tested lubricants met all first article testing requirements
- DuPont Vertrel SDG and Kyzen Cybersolv C141R performed well
- Independent testing conducted by SMI Laboratories confirm solvent alternatives are not corrosive or embrittling to high strength aerospace alloys
- Performance of formulations blended with compliant solvents and **higher** concentrations of proprietary CPC was equal to, or greater than lubricants approved per MIL-L-87177A and MIL-PRF-81309F
- Demonstrated superior performance of the D-5026NS, CPC No. 3 and CPC No. 4 lubricants
- Compliant solvent alternatives can replace the 225T solvent in the current Super Corr-A formulation without compromising the performance of the lubricant



Recommendations

- Work closely with representatives at Hill AFB, DLA, AFRL, and AFCPCO to revise or update the chemical, physical and performance requirements currently referenced in the MIL-L-87177A specification
- A preliminary set of deletions, modifications or additions include:
 - Update flash point requirement based on lubricant chemistry
 - Update or delete the dielectric breakdown requirement based on lubricant chemistry and intended use applications
 - Assess and update oxidation stability requirements
 - Input compatibility requirement with MIL-PRF-32033 and MIL-PRF-81309F lubricants
 - Input Electronics Lubricant Effectiveness tests referenced in MIL-PRF-81309F
 - Initial contact resistance (fixed and disturbed)
 - Low temperature exposures
 - Thermal aging
 - Durability cycling
 - Corrosive gas exposures
 - Compatibility with electrical insulating compounds



Questions & Discussion

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